

Work Order ID 64009

November 23, 2010 7:01:53 AM

dyg 24-25/4



Item ID: D412-698-027

Accept



Setup Start



Revision ID:

Stop



Item Name: Bracket Assembly, LH

Start Date: 11/23/10 Start Qty: 8.00



Cust Item ID:

Required Date: 11/25/10 Req'd Qty: 8.00

Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

DSI 9484

A

100

0.00



DC

Document Control

Memo

0.00

Photocopy bluefile & type labels per PPP D412-698-027/ DSI9484
CHG001

6 w/h/24

dyg for BG 10-11-23

110

Pick Kit

0.00



Packaging

Packaging

Memo

0.00

10/11/24 sf (ex)

120

QC4- 100% Inspect kits for completeness

0.00



QC

Quality Control

Memo

0.00

6 w/h/24

(dyg)

Work Order ID 64009

November 23, 2010 7:01:53 AM

Page 2

Item ID: D412-698-027

Accept

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Start Date: 11/23/10 Start Qty: 8.00

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QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130

0.00



Packaging

Memo

0.00

Identify and pack for shipping as per PPP D412-698-027/ DSI 9484

Location:

PPP rev: *DSI/H*

140

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/11/24 *DSI* *DSI*
10/11/24 *MF*
10-11-24

Picklist Print

November 23, 2010 7:01:52 AM

Page 1

Work Order ID: 64009

Parent Item: D412-698-027

Parent Item Name: Bracket Assembly, LH



Start Date: 11/23/10

Required Date: 11/25/10

Start Qty: 8.00

Required Qty: 8.00

Comments: IPP RevA: new issue DD 09.11.30 verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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.D3199-3

Manufactured No

110

Each

0.0000

1

8 B64011

10/11/24 SP
(82)

Bracket, Fwd LH



DART SERVICE INSTRUCTION

TO AMEND INSTALLATION INSTRUCTIONS IIN-D412-698 REV. E OR LATER APPROVED REVISION
AND ICA-D412-698 REV. 5 OR LATER APPROVED REVISION

REF. TCCA STC: SH92-43
REF. FAA STC: SR01446NY
REF. EASA.IM.R.S.00709

REFERENCE ONLY

Field experience has shown that the forward D3199-1 brackets that are part of the D412-698-011/-012/-017 Cabin Door Roller Kits may wear prematurely if the aircraft is flown a significant amount of time with the sliding doors open. Dart has developed the D412-698-027/-028 kit that includes a longer D3199-3/-4 bracket for installation in the forward 2 positions of the installation to reduce wear on these forward brackets.

The D412-698-027/-028 kits may be installed as follows:

- 1) Remove the sliding door from the aircraft per Section 52.1 of ICA-D412-698
- 2) Remove the forward 2x D3199-1 brackets.
- 3) Install the D3199-3/-4 bracket in place of the removed -1 brackets. Refer to Figure 1 Sheet 2.
- 4) Torque hardware per ICA-D412-698
- 5) Re-install sliding door on aircraft per Section 52.2 of ICA-D412-698
- 6) Make entry in technical records of aircraft indicating that DSI 9484 has been completed

PARTS LIST

QTY -027	QTY. -028	PART NUMBER	DESCRIPTION
X		D412-698-027	BRACKET KIT, LH
	X	D412-698-028	BRACKET KIT, RH
1		D3199-3	FORWARD BRACKET, LH
	1	D3199-4	FORWARD BRACKET, RH

WEIGHT AND BALANCE







Installation	Weight	Lateral		Longitudinal	
		Arm	Moment	Arm	Moment
D412-698-027 Bracket Kit	0.33 lb 0.15 kg	-48.0 in -1.22 m	-15.8 in-lb -0.18 m-kg	102.3 in 2.60 m	33.76 in-lb 0.39 m-kg
D412-698-028 Bracket Kit	0.33 lbs 0.15 kg	+48.0 +1.22 m	+15.8 in-lb +0.18 m-kg	102.3 in 2.60 m	33.76 in-lb 0.39 m-kg

CANADA
DEPARTMENT OF TRANSPORT
AIRCRAFT CERTIFICATION
BRANCH
DAO # 01-O-01

APPROVED

BY: 
D. SHEPHERD (DE # 02)

DATE: 09.10.16
CERT. NO.: SH92-43
ISSUE NO.: 5

A	NEW ISSUE		09.10.16
REV.	DESCRIPTION	BY	DATE
DESIGN		DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN			
CHECKED		DRAWING NO. REV. A	
MFG. APPR.	N/A	DSI 9484 SHEET 1 OF 2	
APPROVED		TITLE SCALE	
DE APPR.		D412-698-027/-028 Kits NTS	
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REFERENCE ONLY

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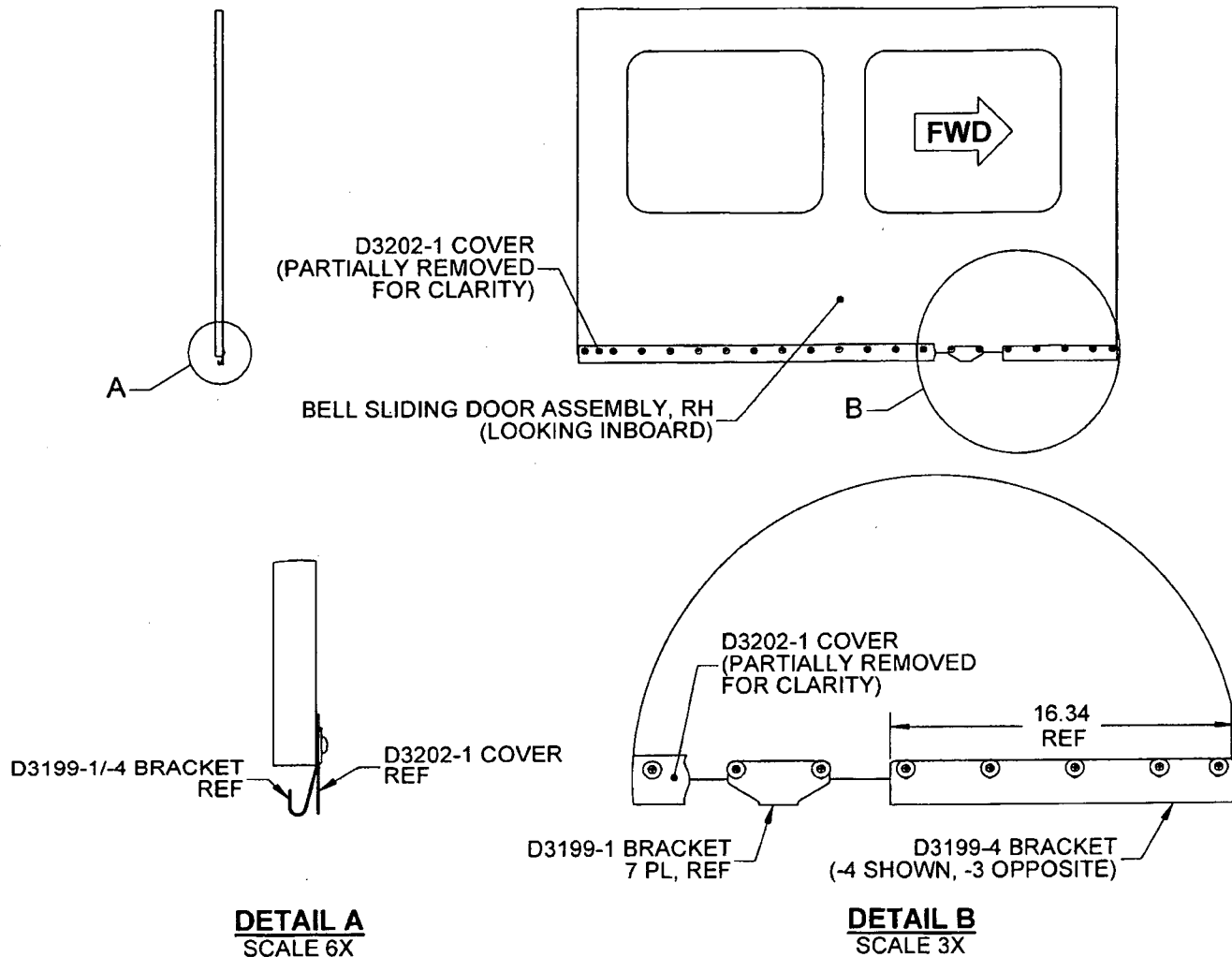


FIGURE 1: D3199-3/4 BRACKET INSTALLATION
(-4 SHOWN, -3 OPPOSITE)

CANADA
DEPARTMENT OF TRANSPORT
AIRCRAFT CERTIFICATION
BRANCH
DAO # 01-O-01

APPROVED
BY: *[Signature]*
D. SHEPHERD (DE # 02)

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